

Work Order ID 61474

Thursday, August 26, 2010 2:38:51 PM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 8/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-8-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



HandFinishing

HandFinish

Memo

0.00

=> M 10/09/01

1 /

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex
241/291. Ensure tube ends line-up with saddle holes for proper alignment. using
7/16" "T" Pins.
A/R ☐ Sikaflex-241/-291 ☐ M115114
Expiry date: ☐ 11/01


2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against
wearplate, then topped with the SS washer. Seal all bolts with sikaflex except
ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 ☐ M115114
Expiry date: ☐ 11/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with
MEK degreaser.
A/R ☐ LPS Procyon ☐ M1114596

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.09.01	110	Acceptable to file inner holes to allow saddle holes to align.	MD	10/09/01	x1	 10.09.01 081042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Required Date: 9/6/2010 Req'd Qty: 1.00




Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC5- Inspect part completeness to step on W/O	0.00				<u>ml</u>	<u>10</u>	<u>09</u>	<u>01</u> (1)
QC Quality Control	Memo	0.00							
130 	Packaging	0.00							
Packaging Packaging	Memo	0.00							<u>10/09/03</u> (1)
	Identify and pack for shipping as per PPP D412-742-043								
	Location: _____								
	PPP Rev: <u>PP 61476</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00						<u>10/09/03</u> (1)	

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Picklist Print

Thursday, August 26, 2010 2:38:56 PM

Page 1

Work Order ID: 61474

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube



Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			110	Each	1,769.000	24	24			
<div> <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>ST303</div> <div>500</div> <div></div> </div> <div> <div>115438</div> <div>500</div> <div></div> </div> <div> <div>ST350</div> <div>1269</div> <div></div> </div> <div> <div>114108</div> <div>14</div> <div></div> </div> <div> <div>114416</div> <div>12</div> <div></div> </div> <div> <div>114523</div> <div>2</div> <div></div> </div> <div> <div>114941</div> <div>241</div> <div></div> </div> <div> <div>115300</div> <div>1000</div> <div></div> </div> </div>													
AN3C6A  BOLT		Purchased	No			110	Each	361.0000	12	12			
<div> <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>ST351</div> <div>361</div> <div></div> </div> <div> <div>111982</div> <div>361</div> <div></div> </div> </div>													

4

YSL 10/09/01

X 24

YSL 10/09/01

VIZ

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W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 61474

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No 110 Each 174.0000 8 8
BOLT
y8 10/09/01

Location	Loc Qty	Loc Code
ST351	174	
105906	4	
107376	4	
113149	121	
114382	45	

AN960C10L NAS1149C0332 Purchased No 110 Each 155.0000 44 44
washer
M 115000 x44 y8 10/09/01

Location	Loc Qty	Loc Code
ST245	155	
107534	29	
109545	54	
111548	72	

D3391-021 ~~Manufactured~~ No 110 Each 0.0000 1 1
Fwd Tube Assembly
A pulled or D3391-023 B# 56618
1356497 x1 y8 10/09/01

D3391-023 Manufactured No 110 Each 1.0000 1 1
Mid Tube Assembly
1356618 x1 y8 10/09/01

Location	Loc Qty	Loc Code
FP	1	
40522	1	

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

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Parent Item Name: Replacement Float Skidtube

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3391-025

Manufactured No

110

Each

1.0000

1

1



Aft Tube Assembly



B356217 x1 H 10109101

Location

Loc Qty

Loc Code

FP

1

48122

1

D3564-1

Manufactured No

110

Each

17.0000

1

1



Wearshoe



H 10109101

Location

Loc Qty

Loc Code

FG

2

33798

2

FP

3

1676

3

FP19

12

58823

12

D3564-3

Manufactured No

110

Each

16.0000

1

1



Wearshoe



H 10109101

Location

Loc Qty

Loc Code

FG

2

33764

2

FP19

14

55489

2

58825

12

x1

Thursday, August 26, 2010 2:38:56 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Work Order ID: 61474

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No

110 Each

20.0000

1

1



Wearshoe



21 10/09/01

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

2

57525

1

58709

1

FP-19

17

59157

6

60868

11

x1

D3566-1 Manufactured No

110 Each

27.0000

2

2



Gasket



21 10/09/01

Location

Loc Qty

Loc Code

FP

3

60857

3

FP015

24

57715

2

60202

12

61215

10

x2

D3566-5 Manufactured No

110 Each

29.0000

1

1



Gasket



21 10/09/01

Location

Loc Qty

Loc Code

FP

22

60869

22

FP015

7

59158

7

x1

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SHOP COPY

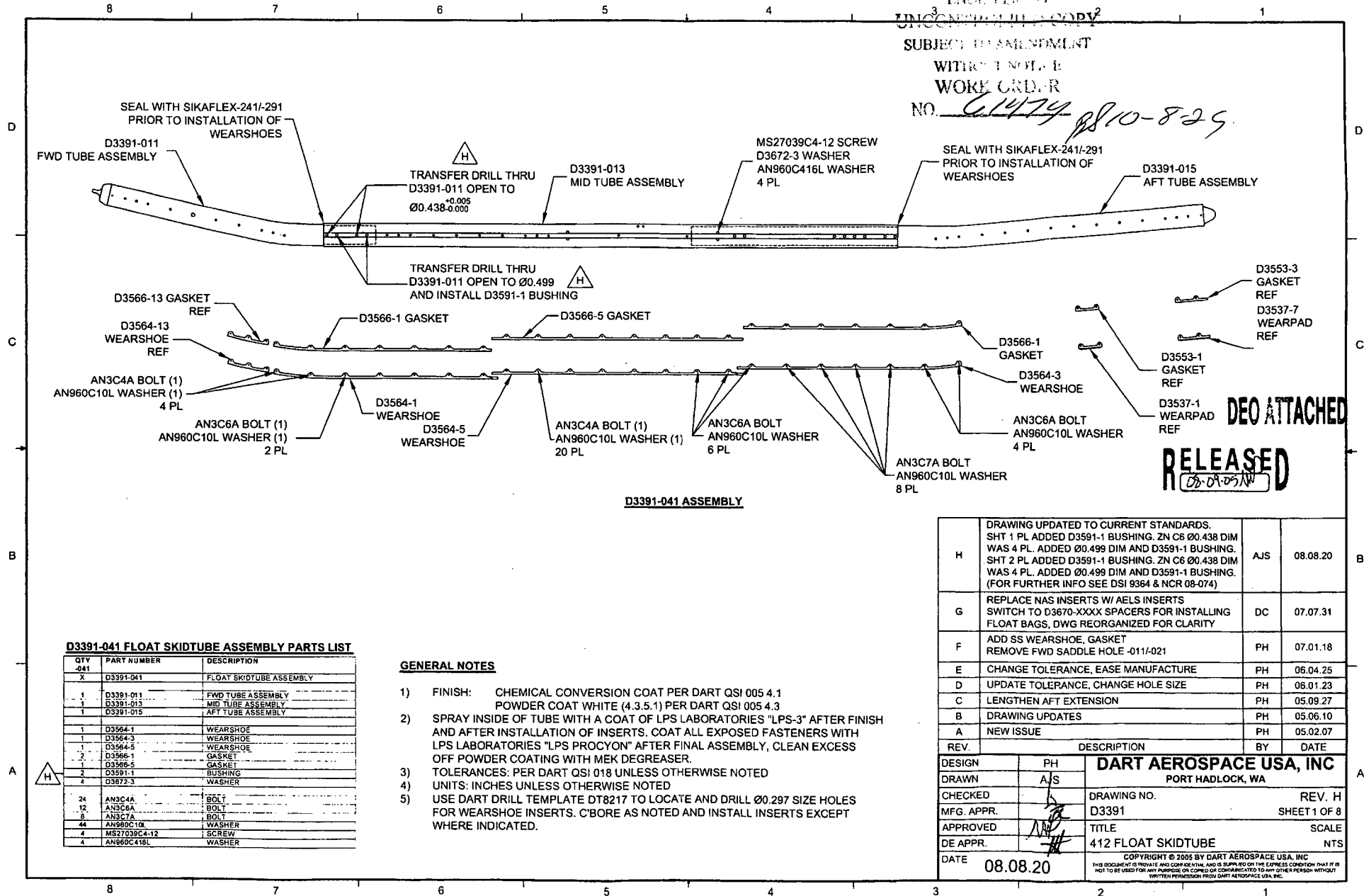
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHIN 1 MONTH
WORK ORDER

NO. 61474 8810-8-25



DEO ATTACHED

RELEASED
08-09-05 NW

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

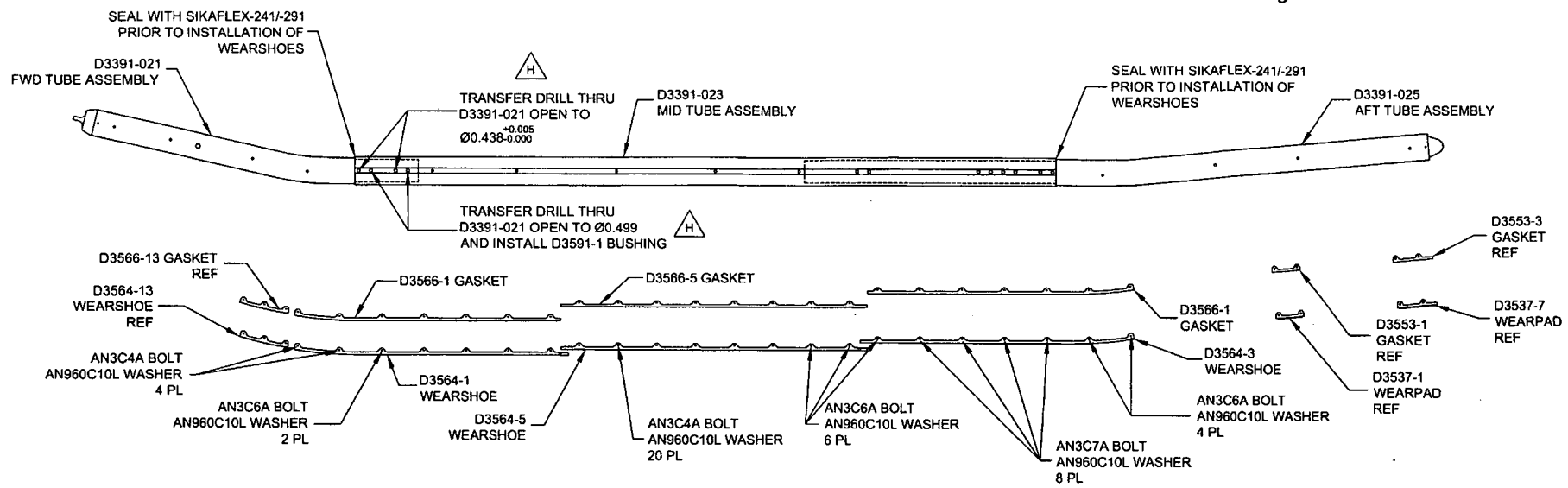
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NOTE: Date & initial all entries

W/O 61474



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED

RELEASED
08 09 05 AM

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

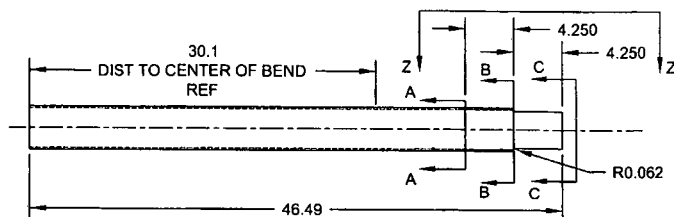
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

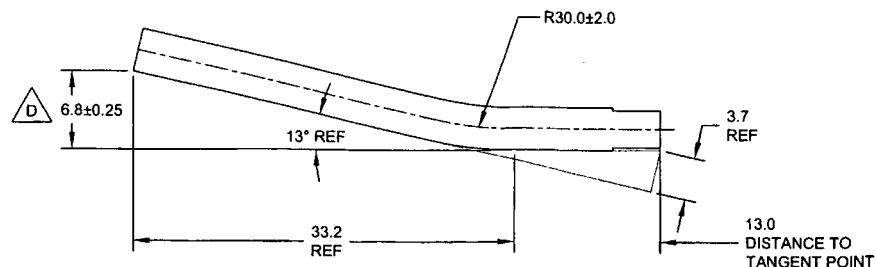
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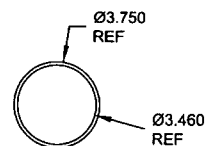
NOTE: Date & initial all entries



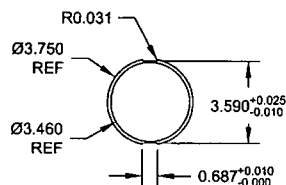
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



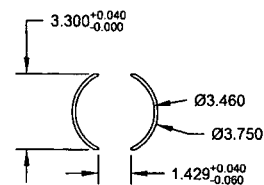
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



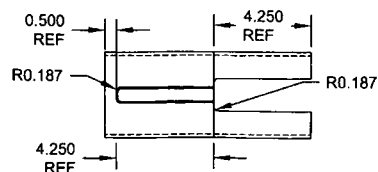
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

w/061479

DEO ATTACHED
RELEASED
08-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
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DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE FIRMEST CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CORRECT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

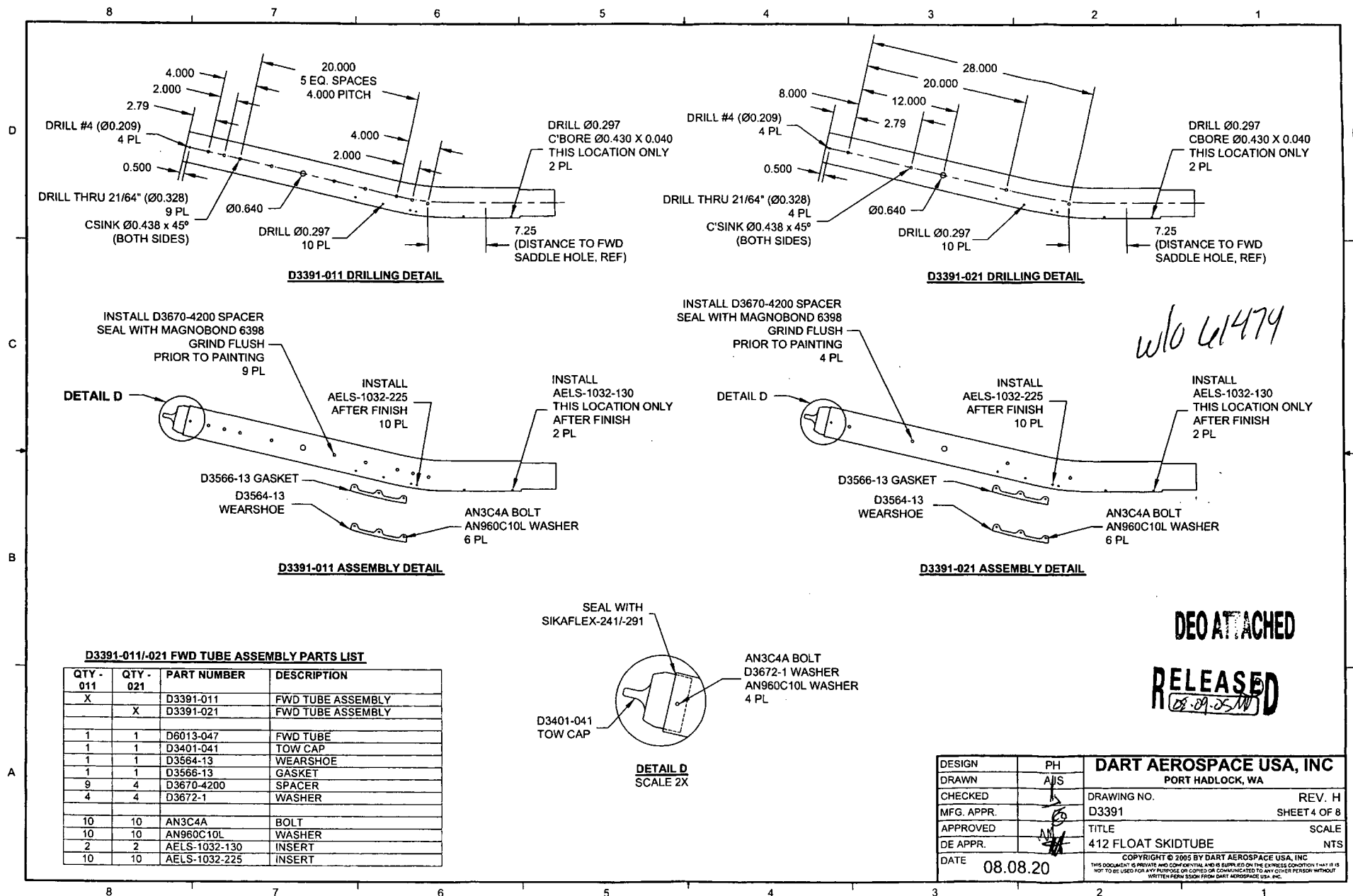
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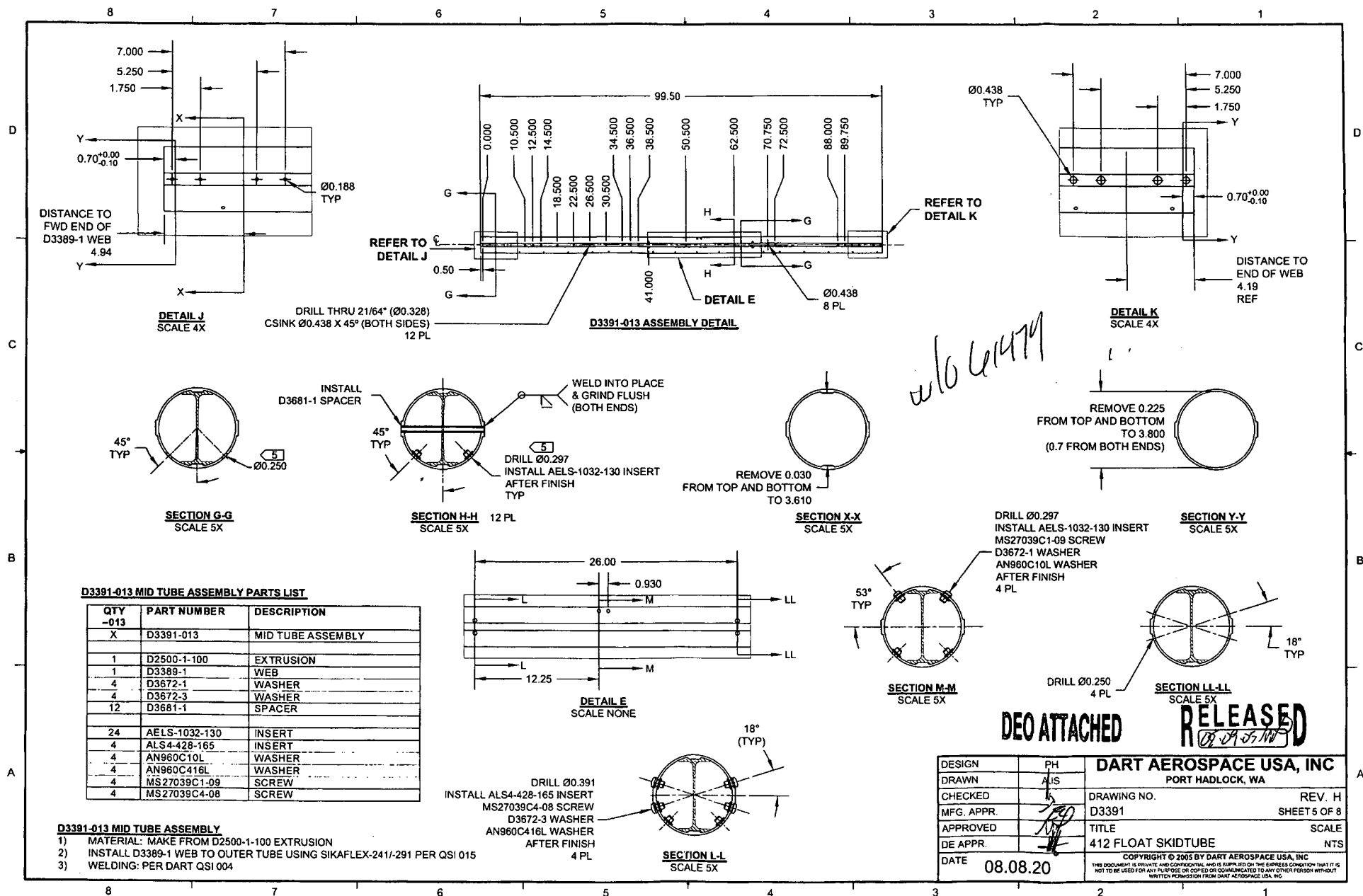
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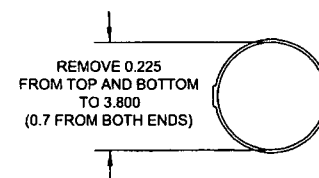
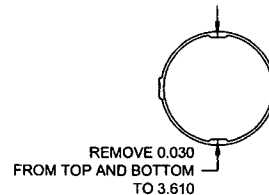
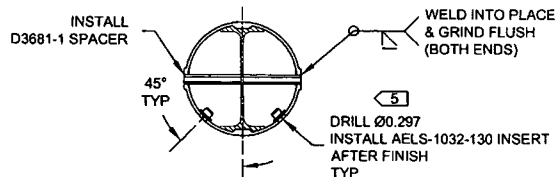
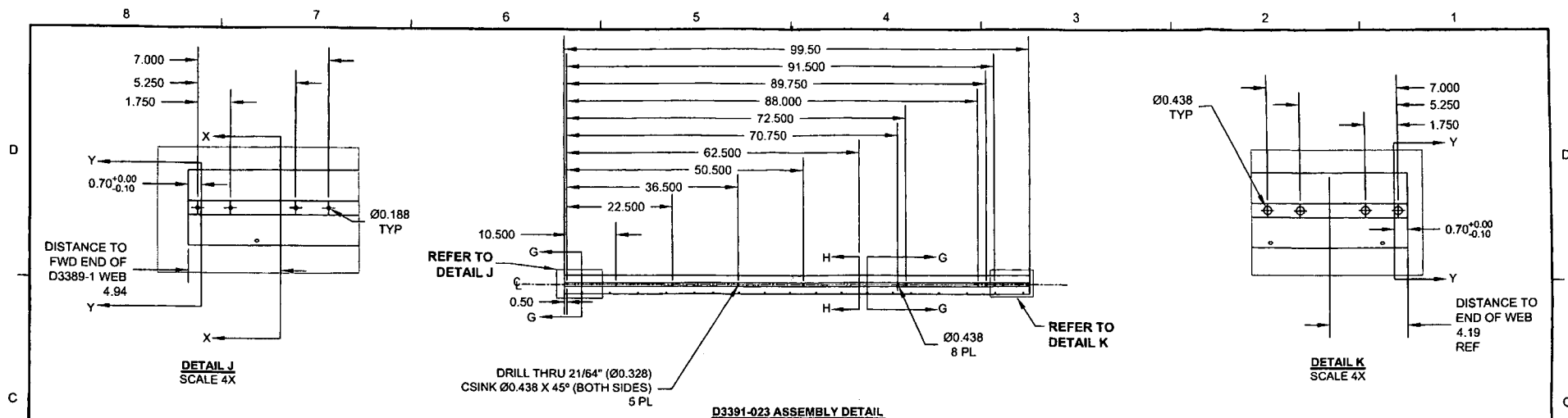
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D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 6 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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RELEASED
08-05-10

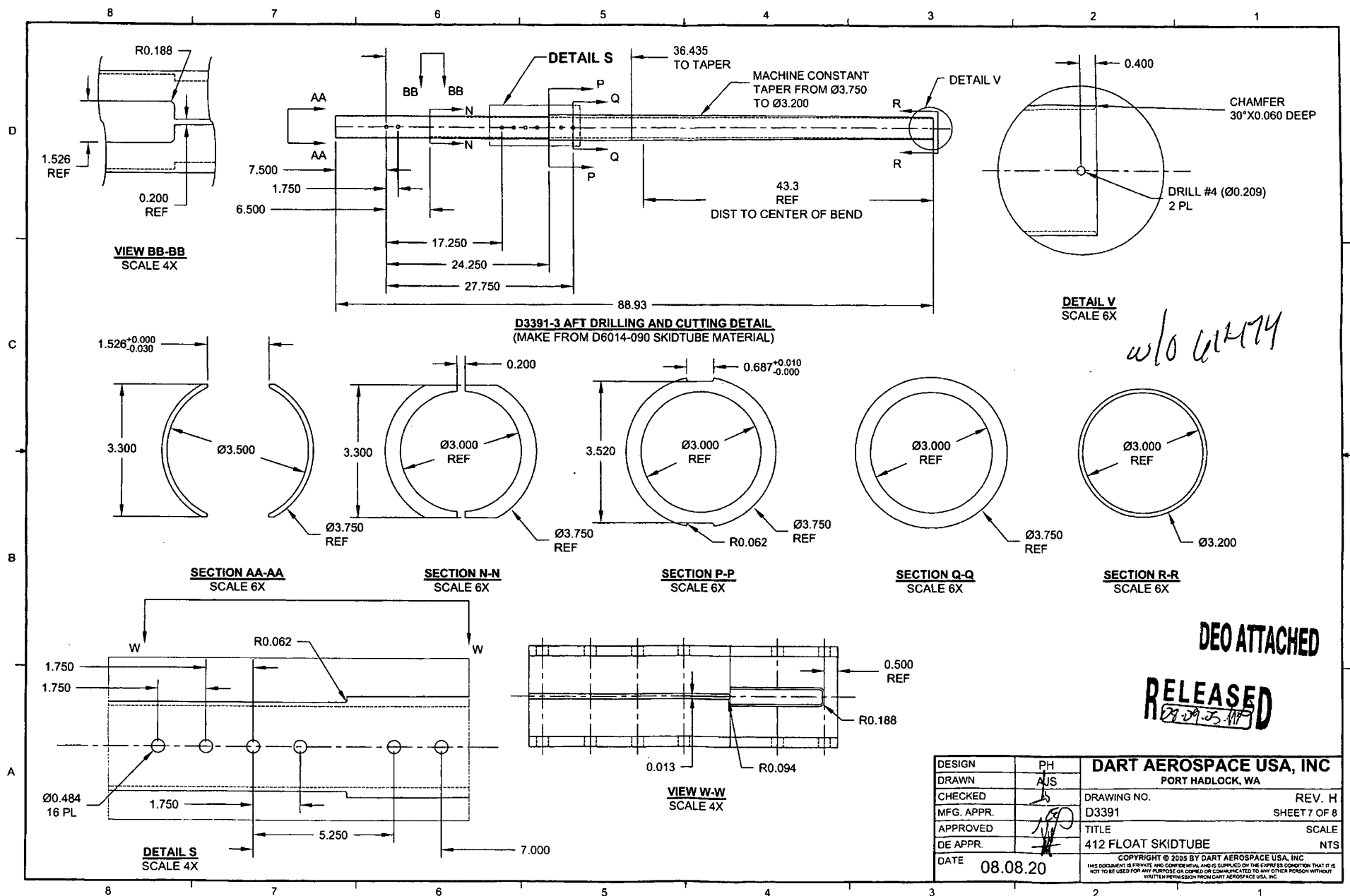
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



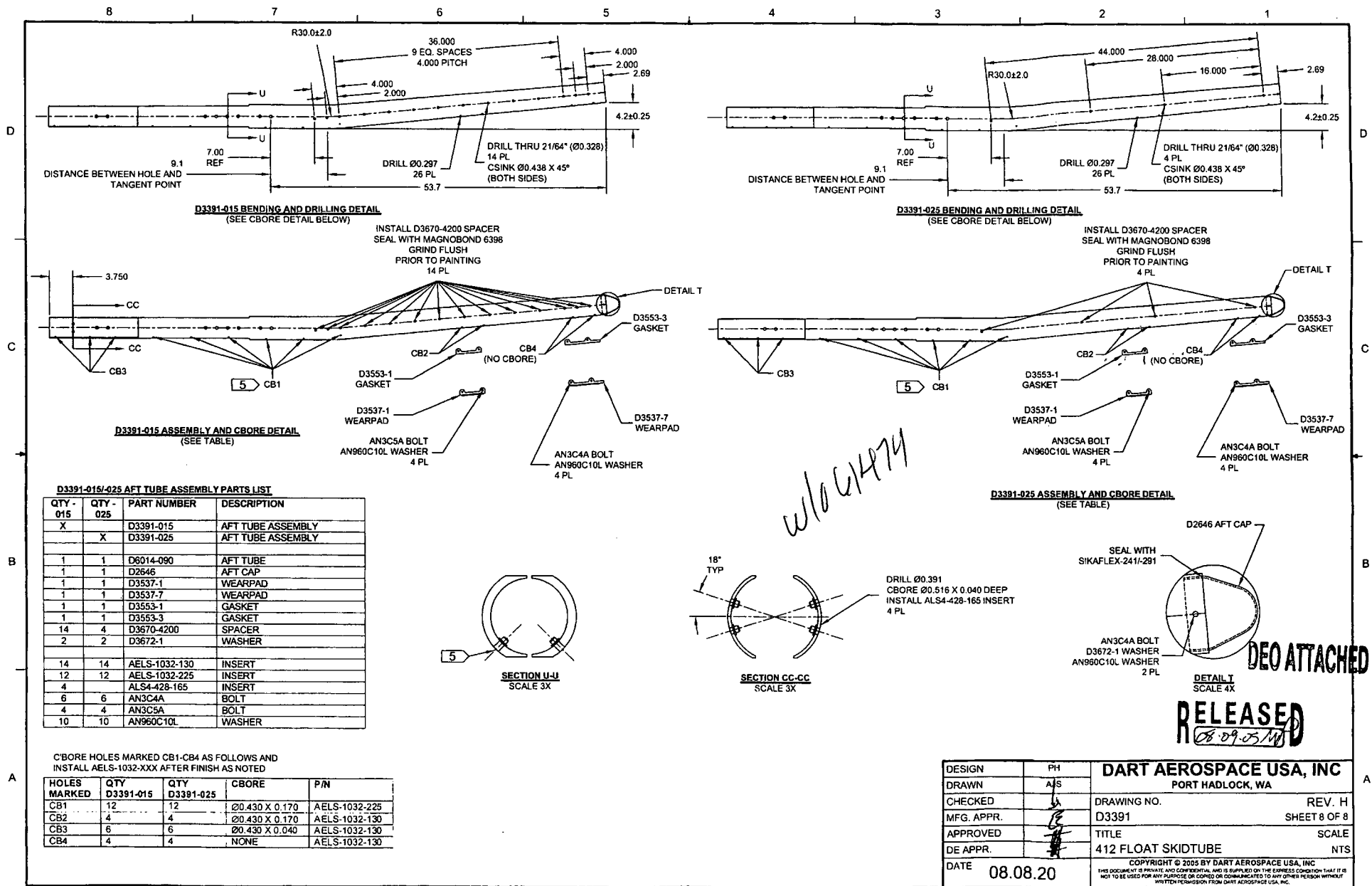
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 06.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02
MP

w/o 61474

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries